

November-27-13 12:43:49 PM

Ship today

Page 1

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 11/27/13 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 11/27/13 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: Process Plan: mt. Date: 13-11-27 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr **Revision Nbr**

D4711 C

110	Pick Kit	0.00
-----	----------	------

110

Packaging Memo

Packaging

**DAS
30
9-89**

13 | 14 | 27

120	0.00
-----	------

120

Small Fab Memo

Small Fab ASSEMBLY

ASSEMBLE AS PER DWG (see note 8,9,10)
 ***DO NOT OVERTIGHTEN THE SHAFT INTO THE BARREL PER NOTE
 10***

DAS
30
9-89

13/4/23

130	QC5- Inspect part completeness to step on W/O	0.00
-----	-----------------------------------------------	------

130

QC Memo

Quality Control

DAS
27
9-89

13/11/27

Work Order ID 109738

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109738

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Item ID: D4711-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Expandable Pin Assembly, Modified
Start Date: 11/27/13 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/27/13 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
140									
Packaging	Memo	0.00		DAS					SO 12/11/27
Packaging				30					
				9-89					
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

[Signature] RM 13/11/27
ME 13-11-27

Picklist Print

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Work Order ID: 109738

Parent Item: D4711-041

Parent Item Name: Expandable Pin Assembly, Modified

Start Date: 11/27/13

Required Date: 11/27/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.10.16 AS PER DWG REV.A DD VERF:JFS IPP REV:B 13.03.11 AS PER
DWG REV.C DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4711-043 Expandable Pin Assembly		Manufactured	No			110	Each	17.0000	1	1		DAS 30 9-89	13/12/27
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST118		4							
				93144		4							
				ST119		7							
				93555		7							
				ST120		6							
				105437		6			1				
D4726-1 Handle		Manufactured	No			110	Each	13.0000	1	1		DAS 30 9-89	13/11/27
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST120		13							
				107390		10			1				
				92205		2							
				93677		1							
D4727-041 Barrel		Manufactured	No			110	Each	7.0000	1	1		DAS 30 9-89	13/11/27
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST120		2							
				102640		1							
				93678		1			1				
				ST121		5							
				105439		5							

Picklist Print

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Work Order ID: 109738

Parent Item: D4711-041

Parent Item Name: Expandable Pin Assembly, Modified

Start Date: 11/27/13

Required Date: 11/27/13

Start Qty: 1.00

Required Qty: 1.00

D4749-1 Manufactured No
Spacer

110 Each 25.0000 1 1

DAS
30
9-89

Location

Loc Qty

Loc Code

ST122

25

102642

2

107194

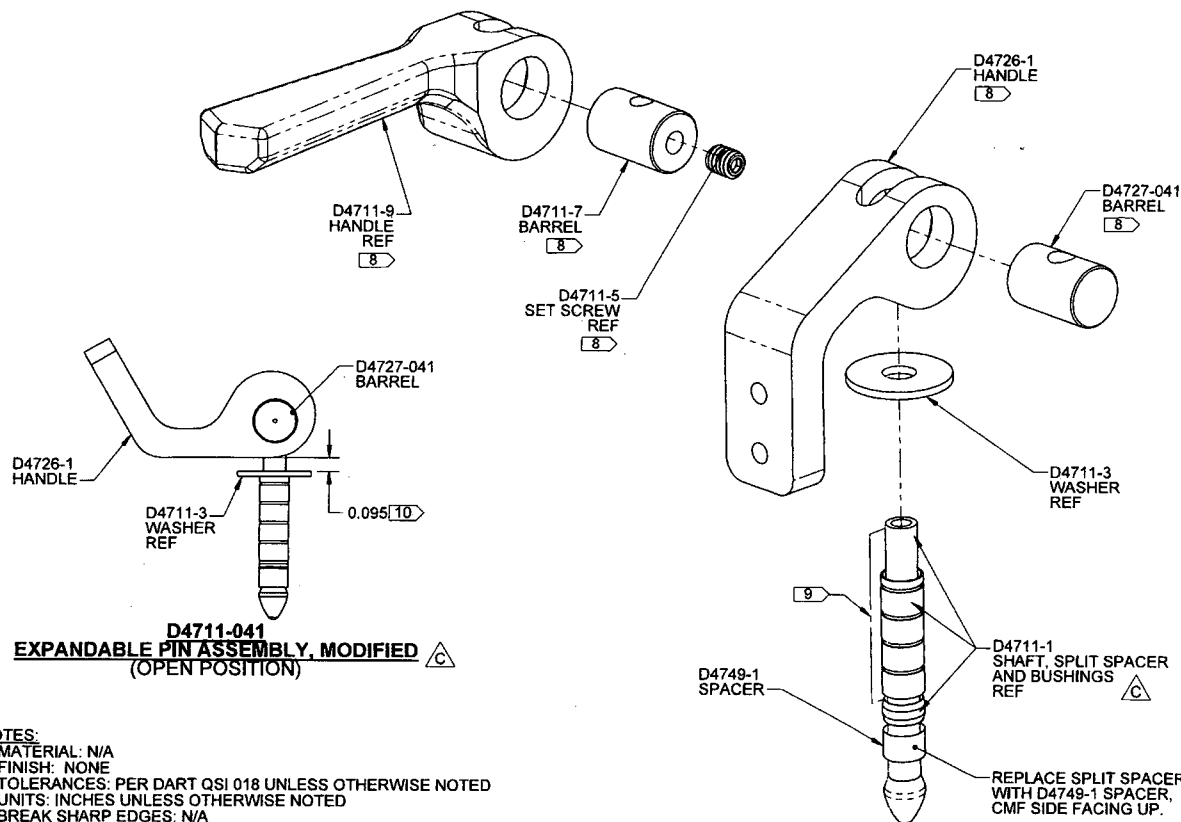
12

94268

11

13/11/28

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4711-041	EXPANDABLE PIN ASSY, MODIFIED
1	1	D4711-043	EXPANDABLE PIN ASSY
2	1	D4726-1	HANDLE
3	1	D4727-041	BARREL
4	1	D4749-1	SPACER



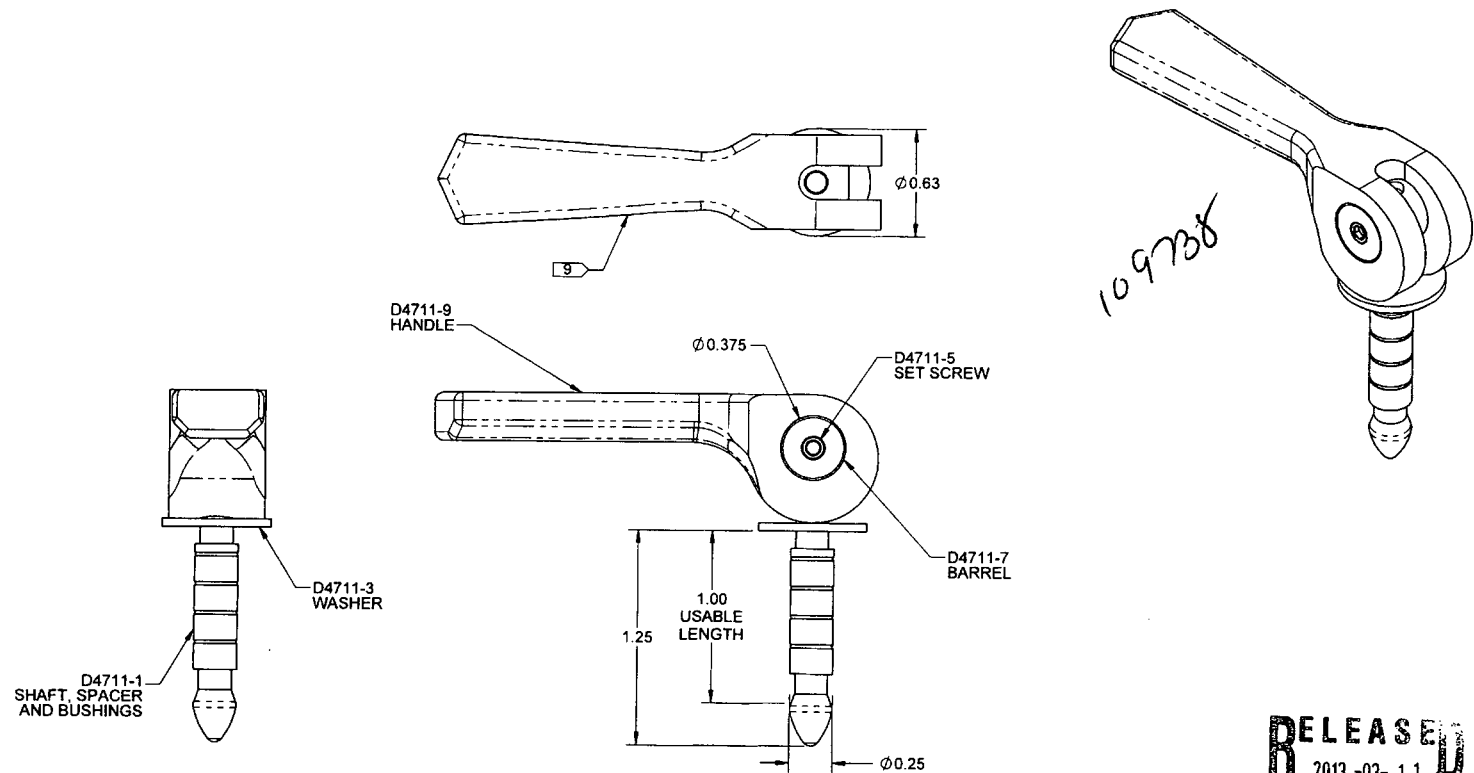
**D4711-041
EXPANDABLE PIN ASSEMBLY, MODIFIED
(CLOSED POSITION)**

RELEASED
2013-03-11

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4711-041" AND B/N "BXXXXX" PER QSI 044 6.7
 - 7) WEIGHT: 0.19 lbs
 - 8) REPLACE D4711-9 HANDLE WITH DART D4726-1 HANDLE.
REPLACE D4711-7 BARREL WITH DART D4727-041 BARREL.
REPLACE BOTTOM SPLIT SPACER WITH D4749-1 SPACER.
DISCARD D4711-5 SET SCREW, D4711-7 BARREL, D4711-9 HANDLE, BOTTOM SPLIT SPACER.
 - 9) WHEN INSTALLING D4749-1 SPACER, ENSURE THAT ALL RETAINED SPLIT SPACERS AND BUSHINGS REMAIN IN THEIR ORIGINAL SEQUENCE AND ORIENTATION.
 - 10) INSTALL THE D4711-1 SHAFT WITH THE ASSEMBLY IN THE OPEN POSITION, UNTIL A GAP OF 0.095" EXISTS BETWEEN THE D4711-3 WASHER AND THE D4726-1 HANDLE. DO NOT OVERTIGHTEN THE SHAFT INTO THE D4727-041 BARREL.

C	REVISED NOTE (A4-1) & NOTE 8. ADDED NOTE 10. PICTORIAL UPDATE. ADDED VIEW B8-1.	AP	13.02.12
B	ADDED D4749-1 SPACER, MODIFIED NOTES 8 AND 9	AP	12.11.23
A	NEW ISSUE	RP	12.09.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	ALS	DRAWING NO.	REV. C
MFG. APPR.	AP	D4711	SHEET 1 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	ADJUSTABLE DIAMETER PIN	NTS
DATE	13.02.12	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

SPECIFICATION CONTROL DRAWING



D4711-043 EXPANDABLE PIN ASSY

NOTES:

- 1) MATERIAL: CORE PIN, SPLIT RINGS & BARREL: STAINLESS STEEL 17-4 PH CONDITION H925 PER AMS 5643
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs
- 8) RECOMMENDED SUPPLIER: MCMASTER CARR P/N 97787A661
- 9) HANDLE, BARREL AND SET SCREW TO BE DISCARDED AT NEXT HIGHER ASSEMBLY

RELEASED
2013-03-11

DESIGN	RP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	ALS	DRAWING NO.	REV. C
MFG. APPR.	4/	D4711	SHEET 2 OF 2
APPROVED	12	TITLE	SCALE
DE APPR.	12	ADJUSTABLE DIAMETER PIN	
DATE	13.02.12	NTS	
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